

Date: Thursday, 02/10/2008 11:00:05 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEB
Job Number	: 42419		
Estimate Number	: 10498		
P.O. Number	:	Part Number	: D2739
This Issue	: 02/10/2008 S.O. No. :	Drawing Number	: D2739 REV D
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 11 Type : SKIDTUBES	Drawing Revision	: D
Previous Run	: 42264	Material	:
Written By	:	Due Date	: 09/10/2008 Qty: 5 Um: Each
Checked & Approved By	: <u>JD 08-10-02</u>		
Comment	: Est Rev: C 02.11.28 Reformat KJ		
	: Est Rev: D 06-03-21 As Per Rev C JLM		
	: Est Rev: E 07-07-28 As per Rev D JLM Verified By:		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D26005108	Extrusion 'I Beam' thin
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)
 Extrusion 'I Beam' thin
 Pick:

Qty Part Number Description Batch

1 D2600-5 Web B 38589JD 8-10-2

2.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

1-Cut D2600-5 to length as per Dwg D2739.

2-Drill pilot holes in web using drilling Jig DT8162 as per Dwg D2739

3-Use uni-bit to open holes to finish size as per Dwg D2739.

4-Bevel Fwd end of extrusion and Deburr holes and ends.

5-Dburr

JD 8-10-2

3.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

JD 8-10-2. (5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 02/10/2008 11:00:05 AM
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Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

JD 8-10-3

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

(5) U 8-10-3

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Use a red or black lead-free paint pen to write the part number and batch number in the middle of each web.

Identify and Stock

Location: LG

JD 8-10-3

7.0

QC21

FINAL INSPECTION/W/O RELEASE



08/10/03

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 8.10.03

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

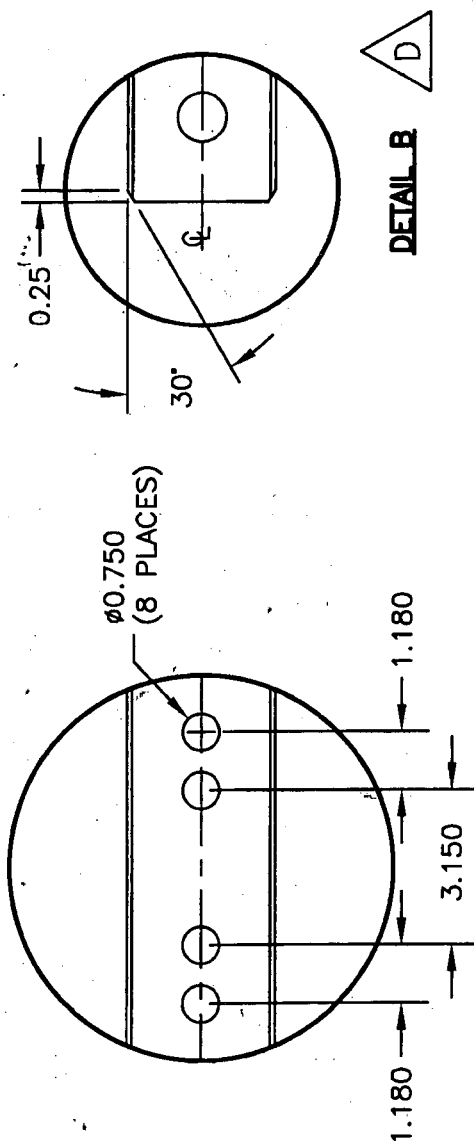
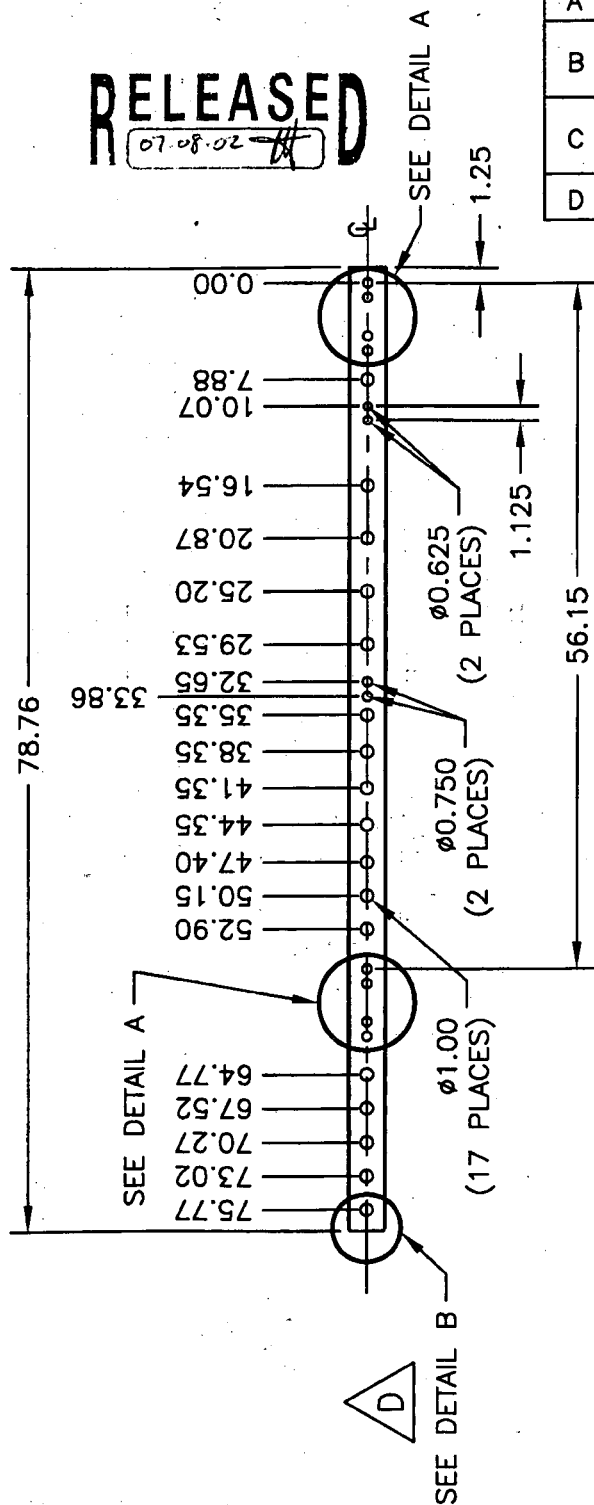
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED
07-08-02

DESIGN PH		DRAWN BY CB		DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH		APPROVED [Signature]		DRAWING NO. D2739	
DATE 07.05.29		TITLE WEB		REV. D SHEET 1 OF 1 SCALE 1:15	
A	98.04.16	NEW ISSUE			
B	98.11.18	CHANGE HOLES FOR COMPATABILITY WITH AIRCRUISER FLOATS			
C	06.01.05	ADD/MOVE HOLES FOR COMPATABILITY W/APICAL FLOATS			
D	07.05.29	ADD BEVEL TO FWD END; ADD DETAIL B			



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 42019

1) MATERIAL: MAKE FROM D2600-5 EXTRUSION
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5) PART IS SYMMETRIC ABOUT C

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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries